



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
order 5782

648.4702
Job Sheet 176676



4

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

003353

A+Planning

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Stores/Pkg-1		18-05-30
110	Small Fab	1 pcs	5/24/18	5/24/18	0.00	1.00	Small Fab-9		18-05-30
120	QC	1 pcs	5/24/18	5/24/18	0.00	0.00	QC4		38
125	DC	1 pcs	5/24/18	5/24/18	0.00	0.00	DC		9-88
130	Packaging	1 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		GA/SS 18-05-31
140	QC21-FG	1 Ea	5/24/18	5/24/18	0.00	0.00	QC21		

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7402

130 - Identify and pack for shipping as per PPP 648.4702

DAS
21
9-88

MAY 31 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5058750
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	5038399
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	50164516
600.1313	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	5029483
AN4-16A	Bolt	3 Ea (3 ea)	90-Start up Operation	5068654
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	5040661
C2-3-1	Bearing DU	2 pcs (2 ea)	90-Start up Operation	5068886
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	90-Start up Operation	5056845
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	5050472
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	90-Start up Operation	5058758
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	5072543
C3-10-2	Lock Spring	1 Ea (1 ea)	90-Start up Operation	5070352
C3-12-1	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	5035073
C3-12-6 (5100-0037-SPP)	Lock Roller Retaining Ring	2 pcs (2 ea)	90-Start up Operation	5060126
C3-13-1 (06FBU04)	Keeper DU-Bearing Bushing	2 pcs (2 ea)	90-Start up Operation	5029270
C3-13-5 (BENDOFF)	Keeper Spring	1 pcs (1 ea)	90-Start up Operation	5029273
C3-3-4-1 (5100-0012-SPP)	Retaining Ring	4 pcs (4 ea)	90-Start up Operation	5032318
C3-3-9	Actuator Spring	1 pcs (1 ea)	90-Start up Operation	5029280
C3-4-1	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	5072098
C3-7-1	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	5062797
C3-7-2	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	5067293
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	90-Start up Operation	5029287

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining		Cross tube ☐ Small Fab		Water Jet ☐ Prod. Eng. Coord. ☐ Aging ☐ Splier ☐		Engineering ☐ Quality ☐ Other ☐	
										MRB (QSI042) Approval	
Description Work _____										Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	

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DART
AEROSPACE

Container No: S076281
 Part: 648.4702
 Job No: 176676
 Serial No/Batch: S076281
 Revision: 4
 Inspector:

Date: 05/30/18

Root Cause			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____			

NAS1149F0463P	Washer ✓	8 Ea (8 ea)	90-Start up Operation	5056461
MS21044N4	Nut, Self-Locking ✓	4 Ea (4 ea)	90-Start up Operation	5058122
AN4-17A	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5067893
MS21083N3	Nut ✓	2 Ea (2 ea)	90-Start up Operation	5036469
NAS1149F0332P	Washer ✓	2 Ea (2 ea)	90-Start up Operation	5068663
MS35266-63	Solenoid Cover Screw ✓	1 Ea (1 ea)	90-Start up Operation	5038767
NAS1149F0363P	Washer ✓	1 Ea (1 ea)	90-Start up Operation	5027738
AN6-15A	Bolt ✓	1 Ea (1 ea)	90-Start up Operation	5076004
MS21083N6	Nut ✓	1 Ea (1 ea)	90-Start up Operation	5036359
NAS1149F0632P	Washer ✓	2 Ea (2 ea)	90-Start up Operation	5048297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	104	0
	188-FSCS-832-5/8	4	180	0
	600.1309-A	1	0	0
	600.1313	1	0	0
	AN4-16A	3	239	0
	AN4-17A	1	163	0
	AN6-15A	1	11	0
	C2-14-2	2	264	0
	C2-3-1	2	0	0
	C2-3-2-1	2	100	0
	C2-3-3-1	1	29	0
	C2-3-5	2	100	0
	C2-3-8	2	6	0
	C3-10-2	1	0	0
	C3-12-1	2	34	0
	C3-12-6 (5100-0037-SPP)	2	0	0
	C3-13-1 (06FDU04)	2	0	0
	C3-13-5 (DENDOFF)	1	0	0
	C3-3-4-1 (5100-0012-SPP)	4	0	0
	C3-3-9	1	0	0
	C3-4-1	2	0	0
	C3-7-1	1	10	0
	C3-7-2	2	0	0
	C3-8-4	1	0	0
	MS21044N4	4	158	0
	MS21083N3	2	87	0
	MS21083N6	1	25	0
	MS35266-63	1	44	0
	NAS1149F0332P	2	1,675	0
	NAS1149F0363P	1	221	0
	NAS1149F0463P	8	481	0
	NAS1149F0632P	2	446	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																